

Date: Friday, 7/20/2007 10:22:23 AM  
 User: Kim Johnston

## Process Sheet

|  |                                      |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : CLEVIS                |
| Job Number : 33709                             |                                      |
| Estimate Number : 10578                        |                                      |
| P.O. Number : <u>N/A</u>                       | Part Number : D34533                 |
| This Issue : 7/20/2007 S.O. No. : <u>N/A</u>   | Drawing Number : D3453 REV A         |
| Prsht Rev. : NC                                | Project Number : N/A                 |
| First Issue : <u>N/A</u> Type : MACHINED PARTS | Drawing Revision : A                 |
| Previous Run : 29678                           | Material : <u>N/A</u>                |
| Written By : _____                             | Due Date : 7/27/2007 Qty: 8 Um: Each |
| Checked & Approved By : <u>[Signature]</u>     |                                      |
| Comment : A 06.09.27 New issue EC              |                                      |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |           |
|-----|-----------|-----------|
| 1.0 | M304R1250 | Inventory |
|-----|-----------|-----------|



Comment: Qty.: 0.2452 f(s)/Unit Total : 1.9616 f(s)  
 Material: AISI 304 SS Round Bar Ø1.250  
 (M304R1.250)  
 Batch: M101549

DSP 07/07/23

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL  
 1-Turn as per Folio FA578 Rev: AA & Dwg D3453 Rev: A  
 2- Deburr as per dwg D3453

DSP 07/07/23 (8)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 07/07/23 (8)

|     |       |                                |
|-----|-------|--------------------------------|
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Mill as per Folio FA578 Rev: AA & Dwg D3453 Rev: A  
 2- Deburr as per dwg 3453

ML 07/07/27 (8)

|     |     |  |
|-----|-----|--|
| 5.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 07/07/27 (8)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   L   Date:   16/7/30  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 7/20/2007 10:22:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 33709

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

J.F.

07/07/28

(8)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F.

07/07/28

(8)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8F 07/07/29

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2

Large fcb.

07/07/30

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/30

(8)

Job Completion



07-07-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

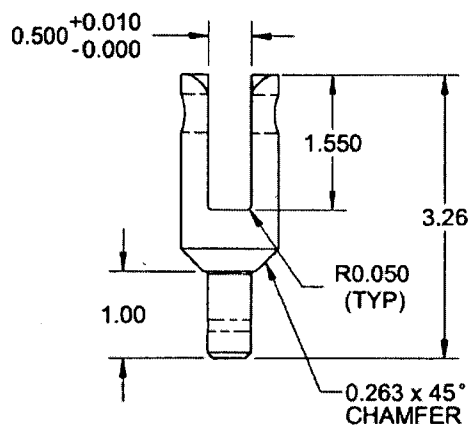
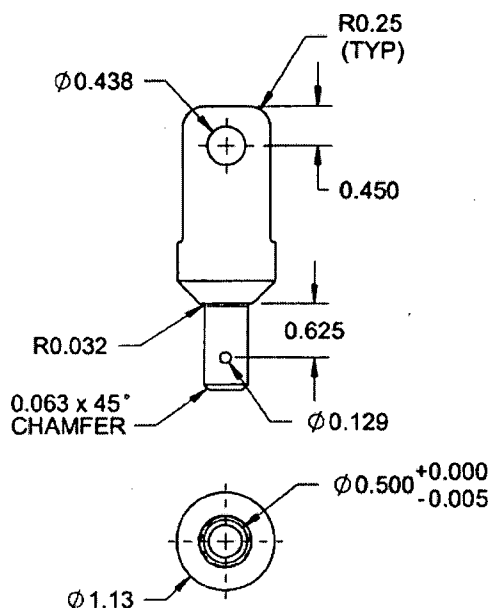
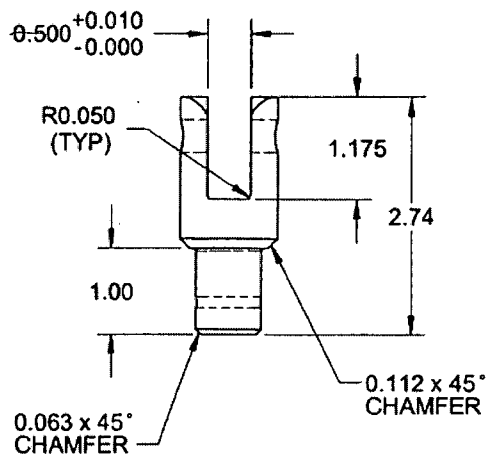
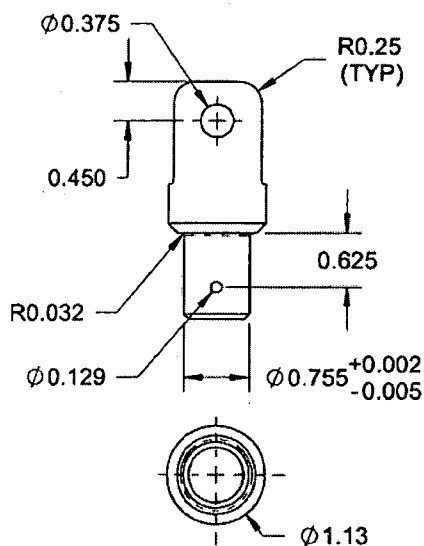
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



**DART**

|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br>RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3453</b>                              | REV. A<br>SHEET 1 OF 2 |
| DATE<br><b>05.09.02</b>       |                                | TITLE<br><b>CLEVIS</b>                                   | SCALE<br>1:2           |
| A                             | 05.09.02                       | NEW ISSUE  |                        |

**D3453-1 CLEVIS****RELEASED**05.12.09 *[Signature]***D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES  $0.005$  TO  $0.010$

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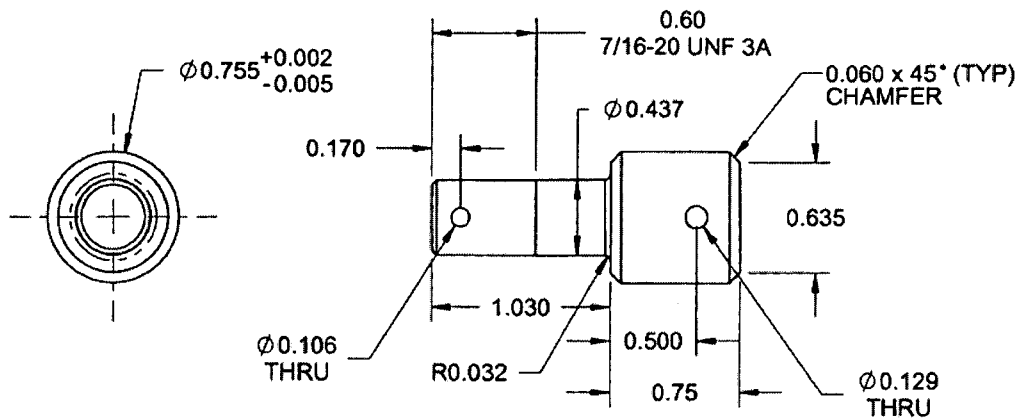
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|                        |                         |   |                        |
|------------------------|-------------------------|---|------------------------|
| DESIGN<br>RF           | DRAWN BY<br>RF          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3453                              | REV. A<br>SHEET 2 OF 2 |
| DATE<br>05.09.02       |                         | TITLE<br>CLEVIS                                   | SCALE<br>1:1           |

RELEASED

05.12.09 [Signature]



**D3453-5 PLUG**

**NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
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- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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